

Date: Wednesday, 12/13/2006 2:39:28 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206B UTILITY BASKET
<b>Job Number</b> : 29920	
<b>Estimate Number</b> : 11282	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D206540013
<b>This Issue</b> : 12/13/2006 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D206-540
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : I
<b>Previous Run</b> : 26139	<b>Material</b> : <i>SLA</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 1/20/2007 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i> 06 12 13	
<b>Comment</b> : Est Rev: I Revised as per Rev I 05-12-07 JLM Est Rev: J reformat 06.04.04 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL  
 Photocopy bluefile & type labels per PPPD206-540-013 CHG004

2.0	29920A	206B BASKET LID
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**Comment:** Sub-Component 206B BASKET LID  
 D2330-043 B *29920 A*

3.0	29920B	206B BASKET BASE
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**Comment:** Sub-Component 206B BASKET BASE  
 D2330-041 B *29920 B*

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Pick: Assembly Kit

*m207/02/07*

5.0	D2332041	Lid Prop Assembly 6.69"
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 Pick: Assembly Kit  
 Qty Part Number Description Batch  
 1 D2332-041 Prop Ass'y *B29134*

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/13/2006 2:39:28 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 29920

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 SPACER B26664

✓

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment B28997

✓

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring B28363

✓

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing B29536

✓

10.0

D2931

Bumper



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 D2931 Bumper B21139

✓

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS20600AD4W3 Rivet M101519

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 12/13/2006 2:39:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 29920

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A Bolt M100327



13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-24A Bolt M101938



14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN3-16A Bolt M100564



15.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Dart Logo label large

Batch: B22553



16.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-22A Bolt M100771



17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN5-17A Bolt M102140



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 29920

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD416 Washer M101938

19.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M102929

20.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M102929

21.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD8 Washer M102842

22.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M102217

23.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) M19185

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206B UTILITY BASKET

Job Number: 29920

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D2258170

Placard - 170 lb



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2258-170 Placard B 16266

✓

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch  
4 MS21042L5 Nut (or -5) M100564

ml 07/02/07

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D206-540

ml 07/02/08

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

For 02-08

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

29.0

D2249041

Fitting Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2249-041 Bracket B23776

✓

30.0

D2022101

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

4 D2022-101 Spacer B26664

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206B UTILITY BASKET

Job Number: 29920

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2012-107 Clevis

B27522 - ✓

32.0

D2259

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2259 Placard

B10671 - ✓

33.0

D2525

Spacer Kit



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2525 Spacer kit

B12105 - ✓

34.0

D2526

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2526 Bushing

B23139 - ✓

35.0

D2748

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2748 Clevis

B23416 - ✓

36.0

D27491

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2749-1 Strut

B11012 - ✓

37.0

D27493

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2749-3 Strut

B11013 - ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 29920

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

D2814

Strut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2814 Strut

B23425 - ✓

39.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-12A

Bolt

M102380 - ✓

40.0

AN412

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-12

Bolt

M7188 - ✓

41.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

8 AN4-5A

Bolt

M100857 - ✓

42.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN5-17A

Bolt

M102170 - ✓

43.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A

Bolt

M11695 - ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 12/13/2006 2:39:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 29920

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

44.0

AN960JD416

Washer



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

19 AN960JD416

Washer

M101938 - ✓

45.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN960JD516

Washer

M102929 - ✓

46.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN970-4

Washer

M102929 - ✓

47.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

M19185 - ✓

48.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5

Nut

M100564 - ✓

49.0

MS27039411

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 MS27039-4-11

Screw

M33055 - ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Q Date: 07/02/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Wednesday, 12/13/2006 2:39:30 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 29920

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

50.0

AN46

Bolts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN4-6 Bolt

~~M 7188~~  
M 9599 -

51.0

AN3204

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN320-4 Nut

M 7195 2X -  
M 7188 1X -

52.0

AN38022

Cotter Pins



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN380-2-2 Cotter pin

M 16895 -  
C 7/02/09 (1)

53.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 207/02/09 (1)

54.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-013

Location: \_\_\_\_\_

PPP Rev: H

C 7/02/09  
C 7/02/09

55.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

C 07/02/10 (1)

Job Completion



U 07.02.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

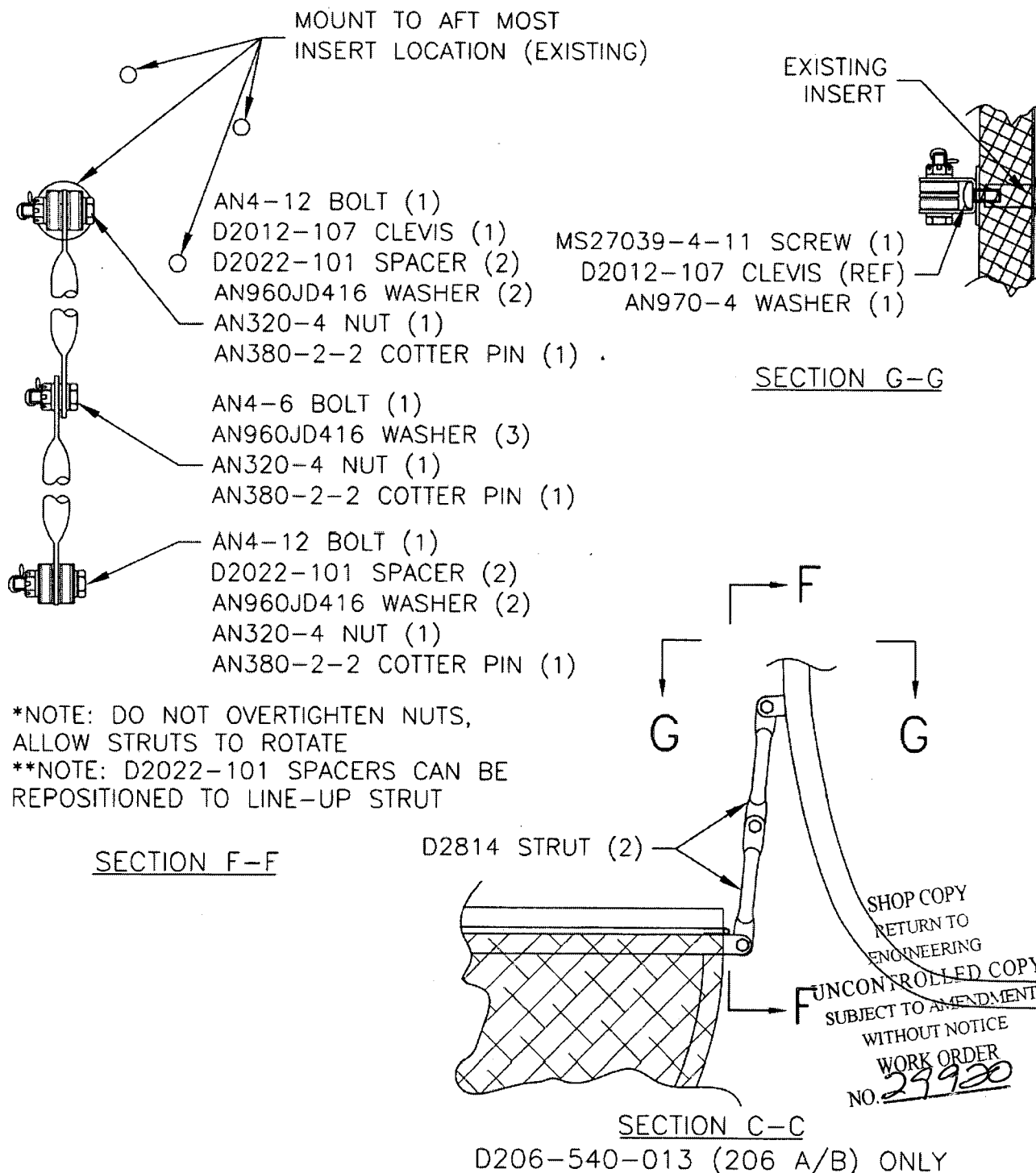
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-540	REV. 1 SHEET 5 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS

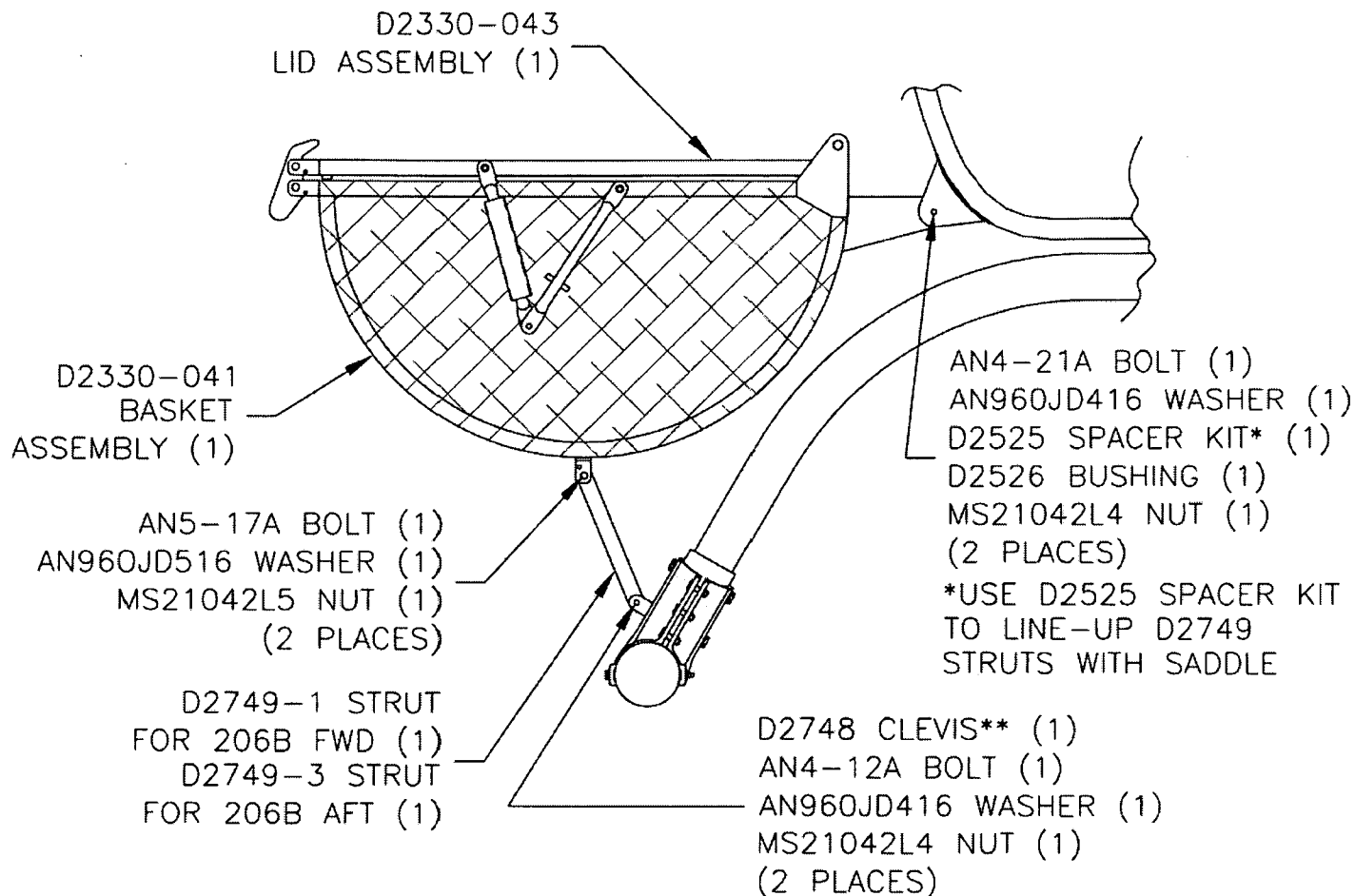


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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
KE	MB	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. 1
<i>[Signature]</i>	<i>[Signature]</i>	D206-540	SHEET 6 OF 8
DATE	TITLE	SCALE	
05.11.10	UTILITY BASKET INSTALLATION	NTS	





\*\*NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748  
CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

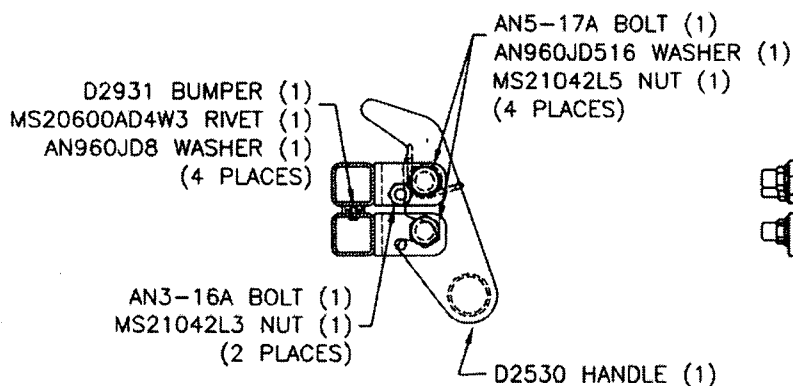
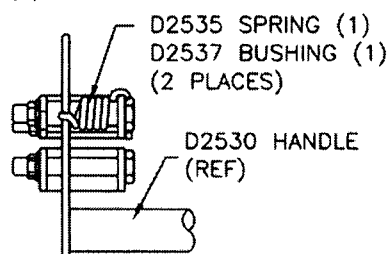
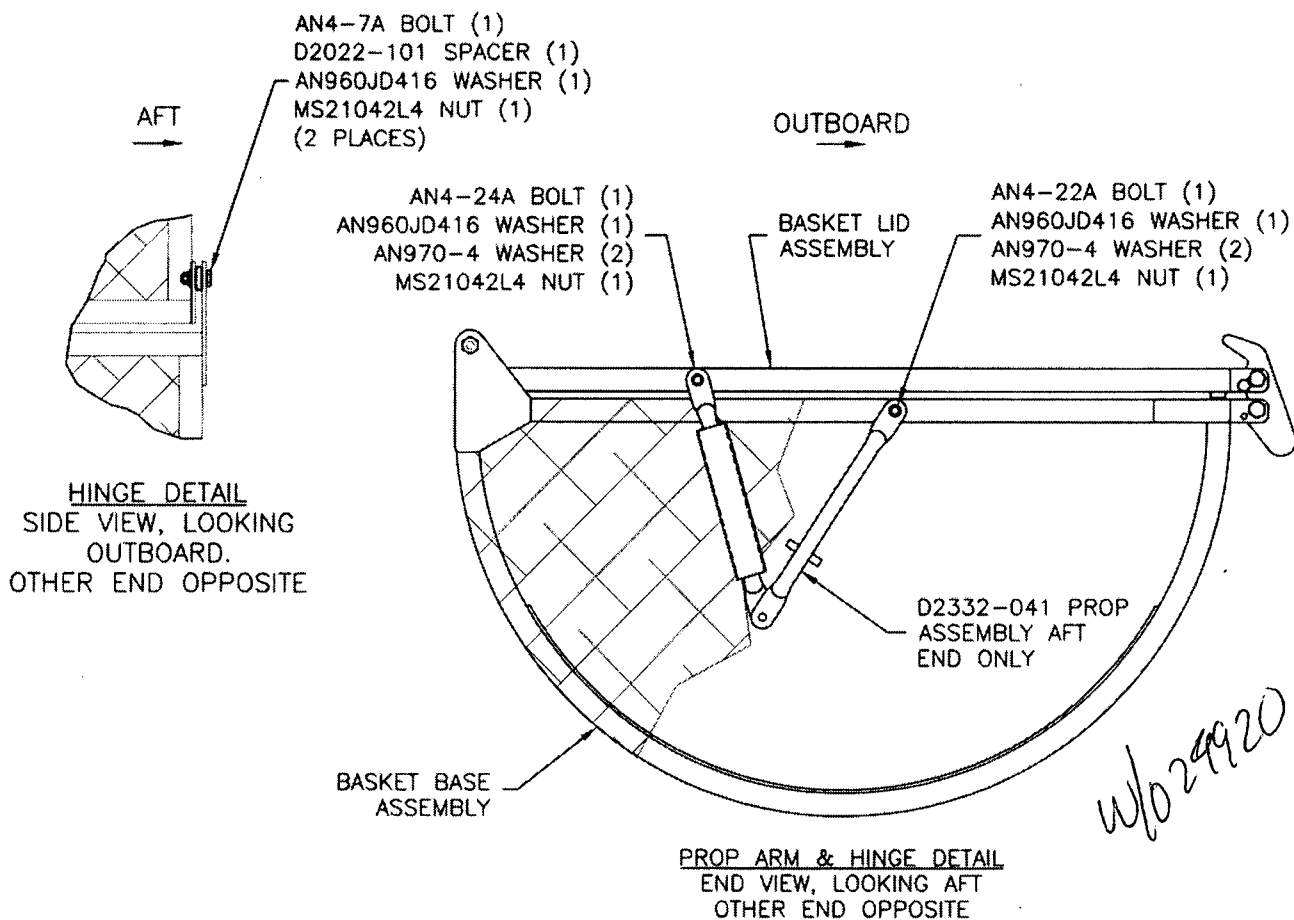
**SECTION A-A AND B-B**  
**D206-540-013 (206 A/B) ONLY**

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 24920

**DART**

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D206-540	REV. 1 SHEET 8 OF 8
DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS

LATCH DETAILSPRING DETAIL**Copyright © 1994 by DART AEROSPACE LTD**

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Date: Wednesday, 12/13/2006 2:39:55 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B BASKET BASE
Job Number	: 29920B		
Estimate Number	: 11276		
P.O. Number	: N/A	Part Number	: D2330041
This Issue	: 12/13/2006 S.O. No. : N/A	Drawing Number	: D2330 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: E
Previous Run	: 26139B	Material	: N/A
Written By	: <u>                    </u>	Due Date	: 1/20/2007
Checked & Approved By	: <u>                    </u>	Qty:	1 Um: Each
Comment	: Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31661	Basket Hoop
-----	--------	-------------



✓ Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part# Description Batch

4 D3166-1 Hoop B29610Ppl 07-01-29

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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✓ Comment: Qty.: 25.3019 f(s)/Unit Total : 25.3019 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M103098Ppl 07-01-29

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 4 D2235-1 From D3166-1

2- Cut D2330-1-3-5-7-9 as per Dwg D2330

3-Drill hole in D2330-3 as per Dwg D2330

4-Deburr

Ppl 07-01-29

4.0	D22531	Lug
-----	--------	-----



✓ Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gusset

Batch: B12413\*Ppl 07-01-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/13/2006 2:39:55 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 29920B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2012-107 Clevis

B27522

Cpl 07-01-29

6.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing

B28597

Cpl 07-01-29

7.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581 Mounting Channel

B28915

Cpl 07-01-29

8.0

D2254

Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2254 Lug

B23421

Cpl 07-01-29

9.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 HINGE

B29132

Cpl 07-01-29

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 31.5000 sf(s)/Unit Total: 31.5000 sf(s)

Pick:

Qty Part Number Description Batch

30 sf M304EX0.75-16F Expanded Metal

M102860

Cpl 07-01-29



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/13/2006 2:39:55 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 29920B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner JigDeburr as required

A/R SS ROD Batch: m 102756

*qpl 07-01-29*

*PTO*

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/01/30*

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/01/30*

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*m 103141*

*FL/Y*

*07/02/07 ①*

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*m 07/02/07*

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

*m 07/02/07*

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/02/12*

Job Completion



*W 07-02-09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/02/12

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/30	11.0	Drill one hole on both Side of base to instal bushing A2327-3 Needed one hole and one bushing	Qs1042	Plug hole with weld and grind flush as per Dwg / Scrap one A2327-3	QPL 07/01/30	MS 07/01/30	Qs1042	MS 07/01/30

NOTE: Date & initial all entries

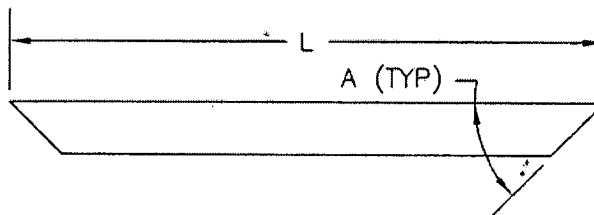
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DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2330	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS
C	96.05.23	ADDED LATCH AND LABEL PLATE	
D	99.09.14	MODIFIED LATCH, REDREW	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2330-11	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2330-041	BASKET ASSEMBLY		
	X	D2330-043	LID ASSEMBLY		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
2		D2330-1	FRAME	84.00	45
2	2	D2330-3	FRAME	25.50	45
1		D2330-5	FRAME	32.75	90
1		D2330-7	FRAME	24.25	90
1	2	D2330-9	FRAME	24.00	90
	2	D2330-11	FRAME	83.27	45
	2	D2330-13	FRAME	23.63	90
	1	D2330-15	FRAME	33.00	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

## NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
(REF. DART SPEC. M304TS0.075W.0.60)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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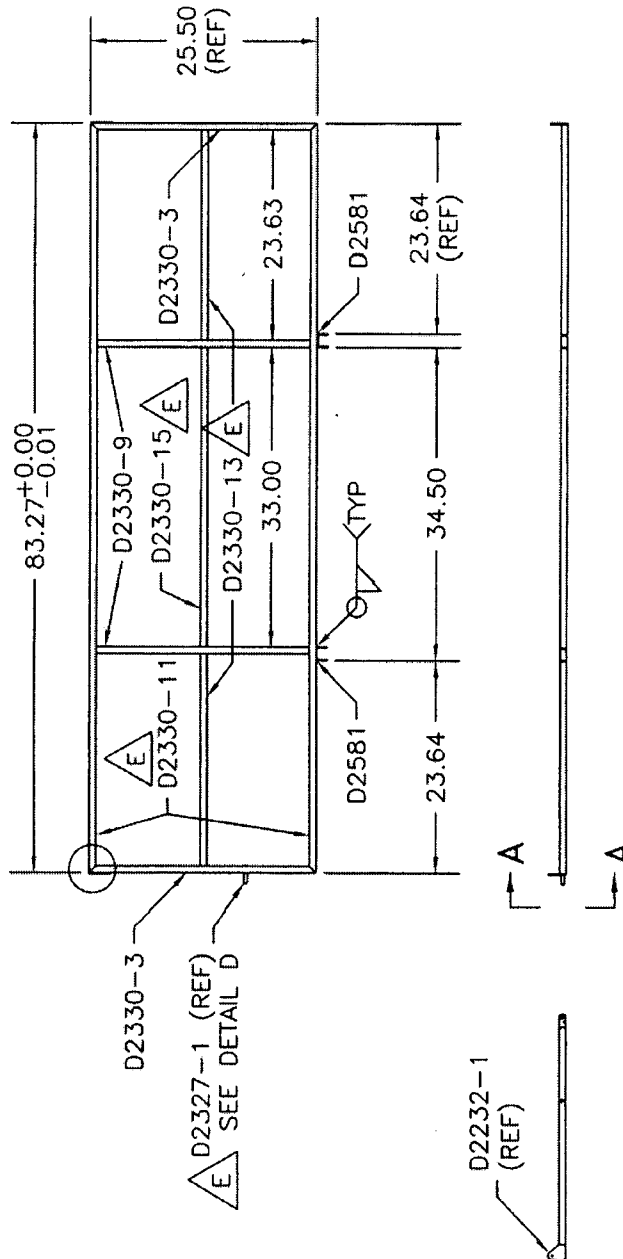
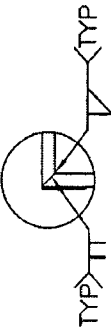
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DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS

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05.11.26

WELD ALL JOINTS  
AS SHOWN



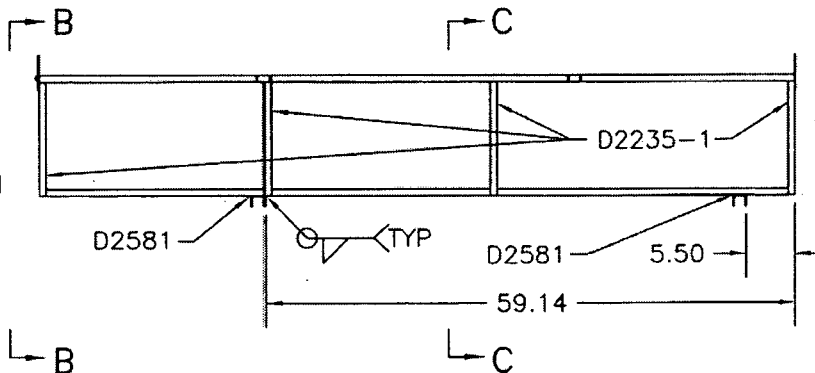
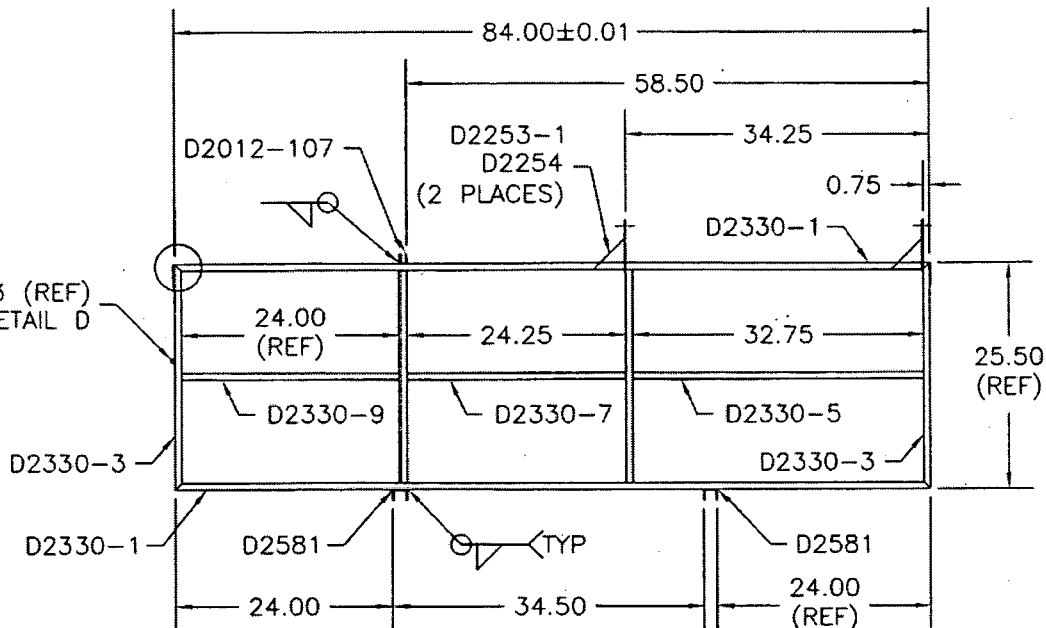
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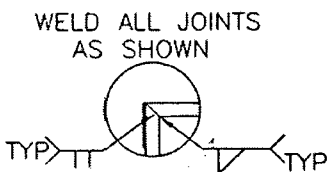
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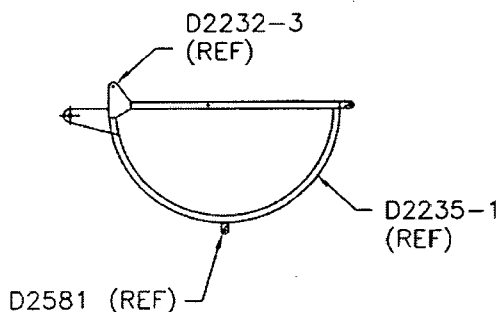
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DATE 05.11.10	TITLE BASKET ASSEMBLY (2068)	REV. E SHEET 3 OF 5
		SCALE NTS



D2330-041 BASKET FRAME



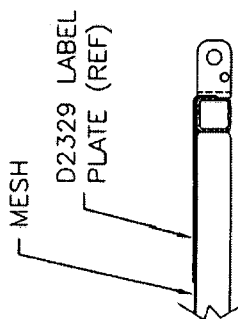
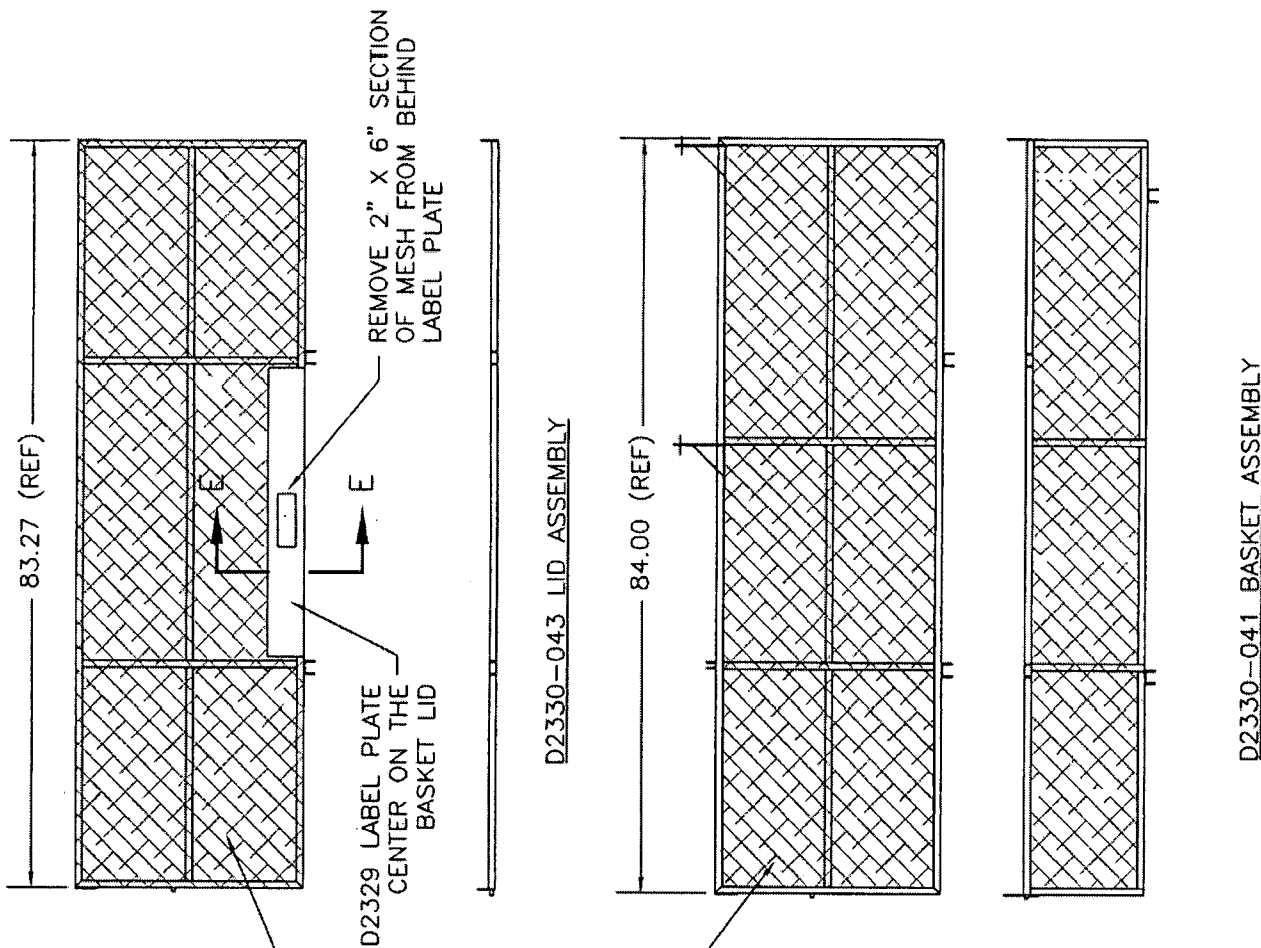
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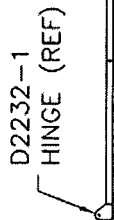
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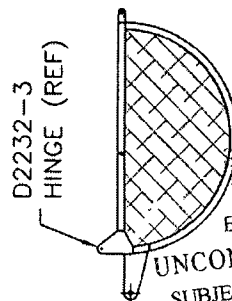
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS



SECTION E-E



SKIN WITH 3/4-16 F  
EXPANDED SS, TACK  
WELD EACH STRAND  
END TO FRAME



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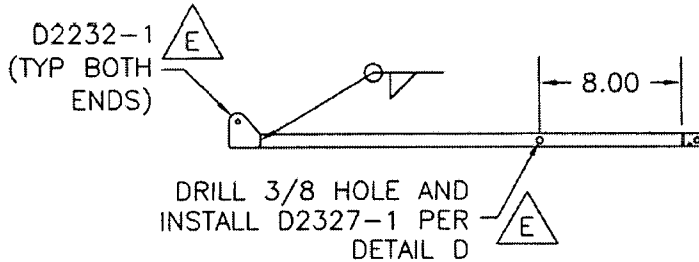
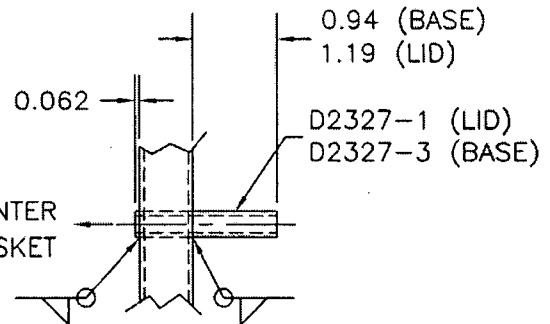
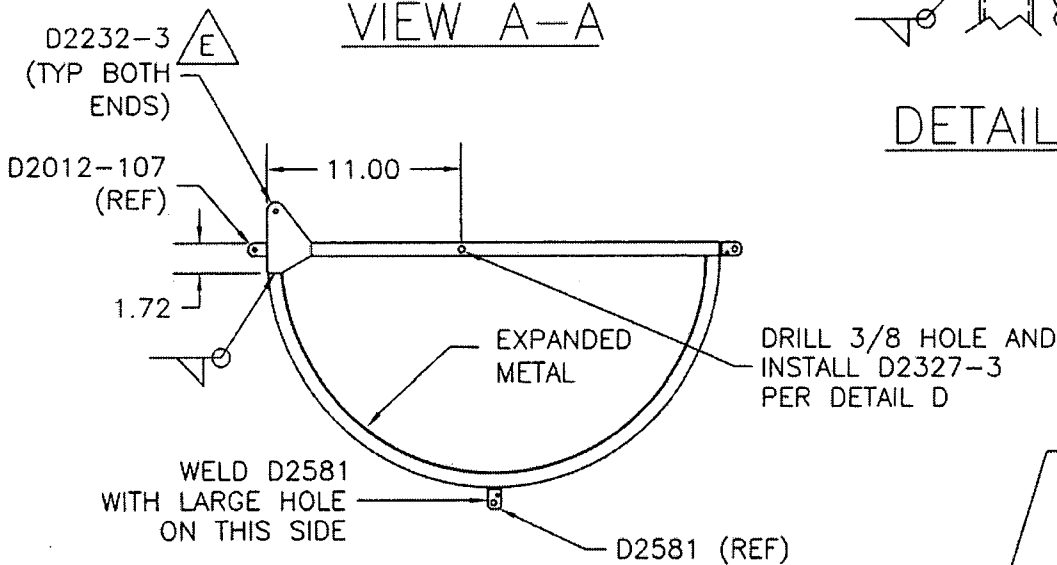
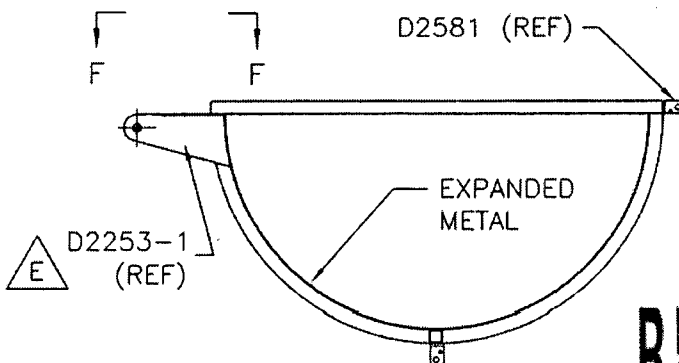
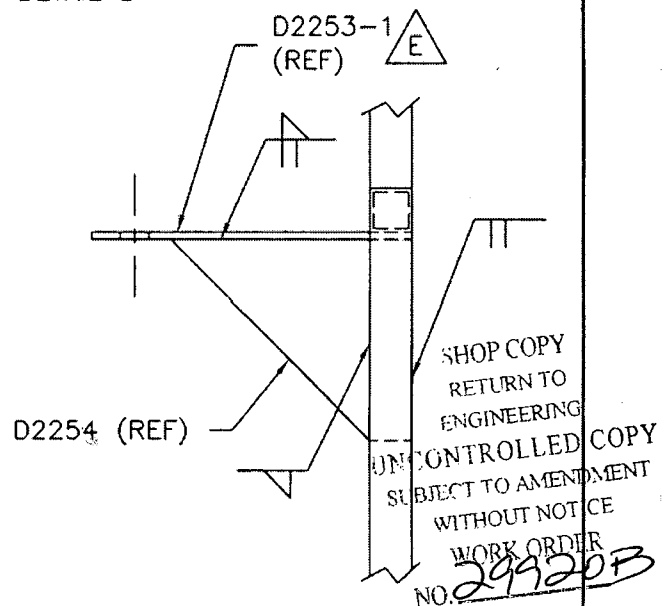
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2330	REV. E SHEET 5 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS

VIEW A-ADETAIL DVIEW B-BVIEW C-CVIEW F-F**RELEASED**  
05.11.26

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Date: Wednesday, 12/13/2006 2:39:40 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B BASKET LID
Job Number	: 29920A		
Estimate Number	: 11280		
P.O. Number	: <i>N/A</i>	Part Number	: D2330043
This Issue	: 12/13/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2330 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: E
Previous Run	: 26139A	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 1/20/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	: Est Rev: H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



✓ Comment: Qty.: 23.3625 f(s)/Unit Total : 23.3625 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: *M102765**PCL 07-01-30*

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2330-1-3-9 as per Dwg D2330

2-Drill hole in D2330-3 as per Dwg D2330

3-Deburr

*PCL 07-01-30*

3.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2232-1 HINGE

*B29535**PCL 07-01-30*

4.0

D2329

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2329 Label Plate

*~~B23217~~ B23490**PCL 07-01-30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID

Job Number: 29920A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23271

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-1 Bushing B28334

*Cpl 07-01-30*

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Chancel B28915

*Cpl 07-01-30*

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total: 18.9000 sf(s)

Pick:

Qty Part Number Description Batch

18 sf M304EX0.75-16F Expanded Metal M102860

*Cpl 07-01-30*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner Jig

Deburr as required

A/R SS ROD Batch: M102756

*Cpl 07-01-30*

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*11/07/01/30*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*11/07/01/30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/02/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/13/2006 2:39:40 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID

Job Number: 29920A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

POWDER COATING



m/03141



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FR/YR

07/02/07/

①

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m/07/02/07

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

m/07/02/07

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/12 ①

Job Completion



UL 07.02.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

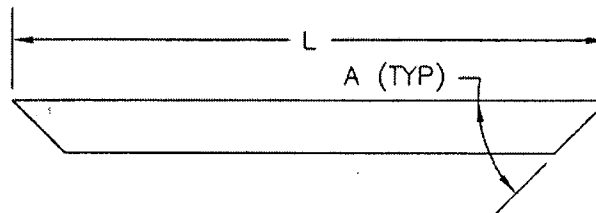
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CHECKED H	APPROVED H	DRAWING NO. D2330	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS
C	96.05.23	ADDED LATCH AND LABEL PLATE	
D	99.09.14	MODIFIED LATCH, REDREW	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2330-11	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2330-041	BASKET ASSEMBLY		
	X	D2330-043	LID ASSEMBLY		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
2		D2330-1	FRAME	84.00	45
2	2	D2330-3	FRAME	25.50	45
1		D2330-5	FRAME	32.75	90
1		D2330-7	FRAME	24.25	90
1	2	D2330-9	FRAME	24.00	90
	2	D2330-11	FRAME	83.27	45
	2	D2330-13	FRAME	23.63	90
	1	D2330-15	FRAME	33.00	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

**NOTES:**

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
(REF. DART SPEC. M304TS0.075W.0.60)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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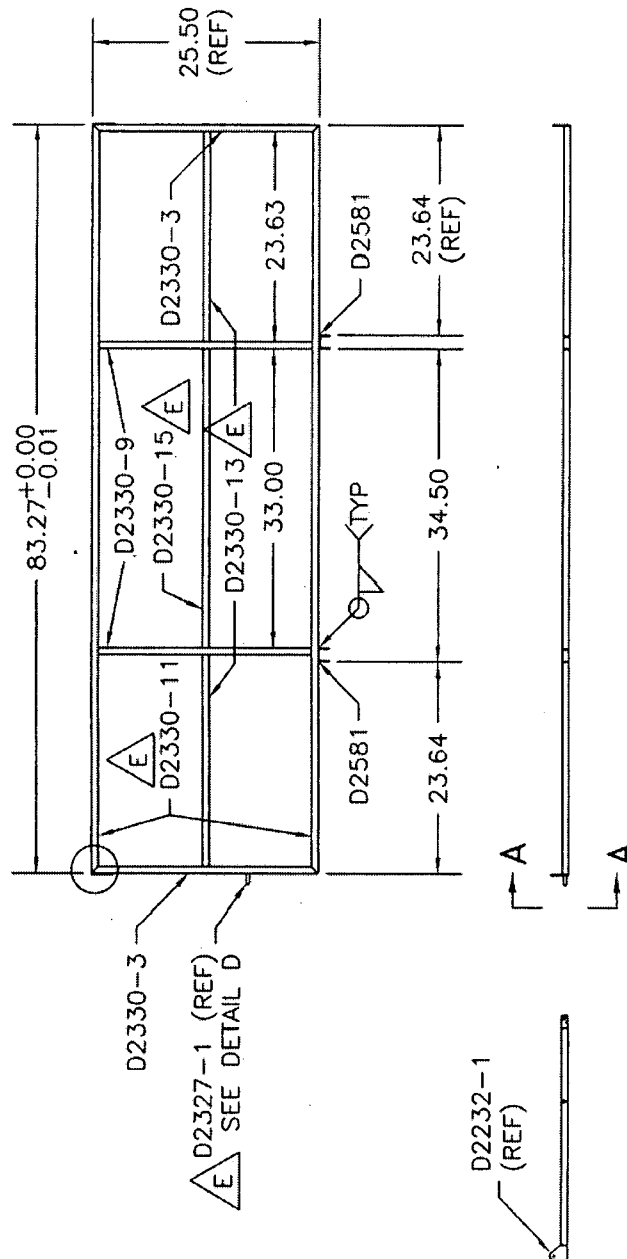
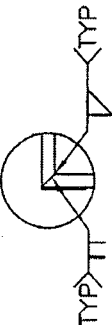
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DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS

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WELD ALL JOINTS  
AS SHOWN



D2330-043 LID FRAME

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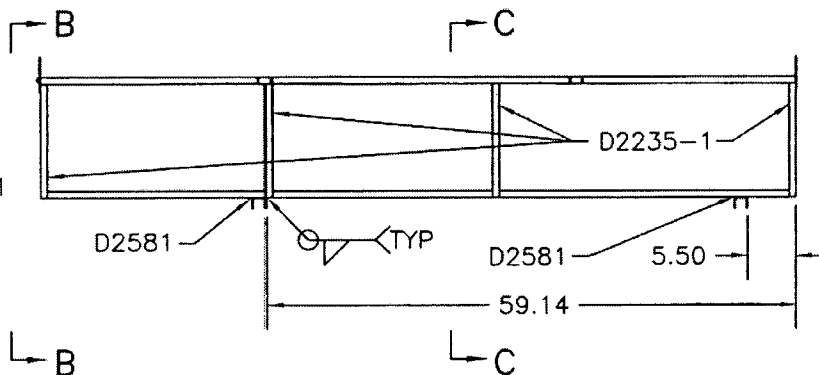
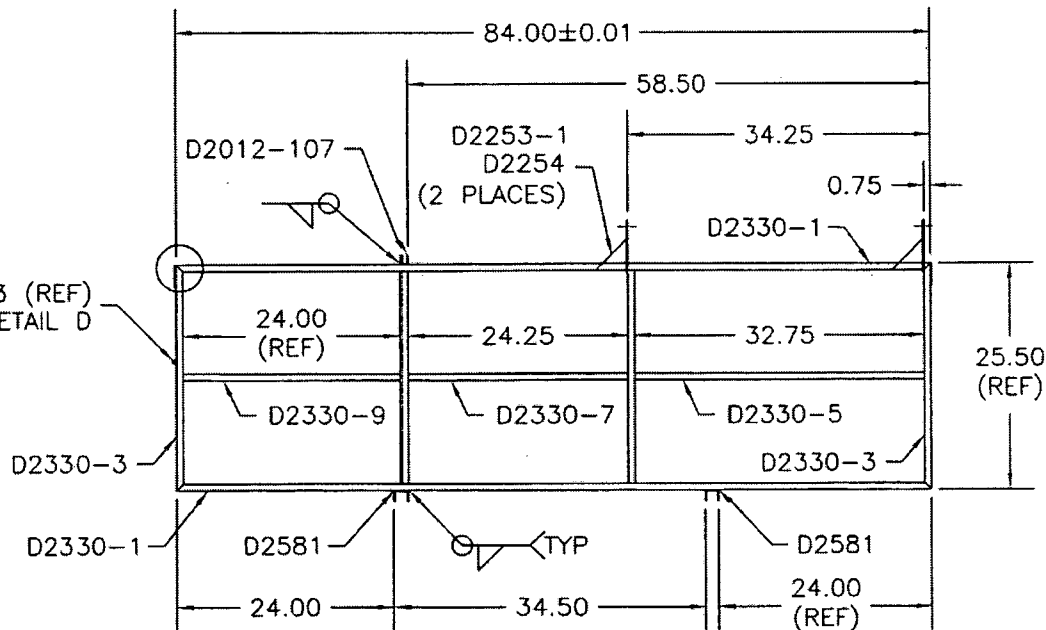
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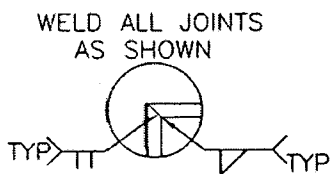


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
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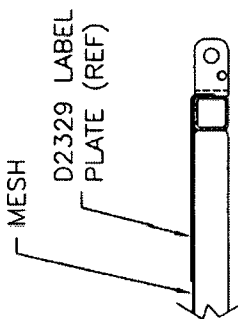
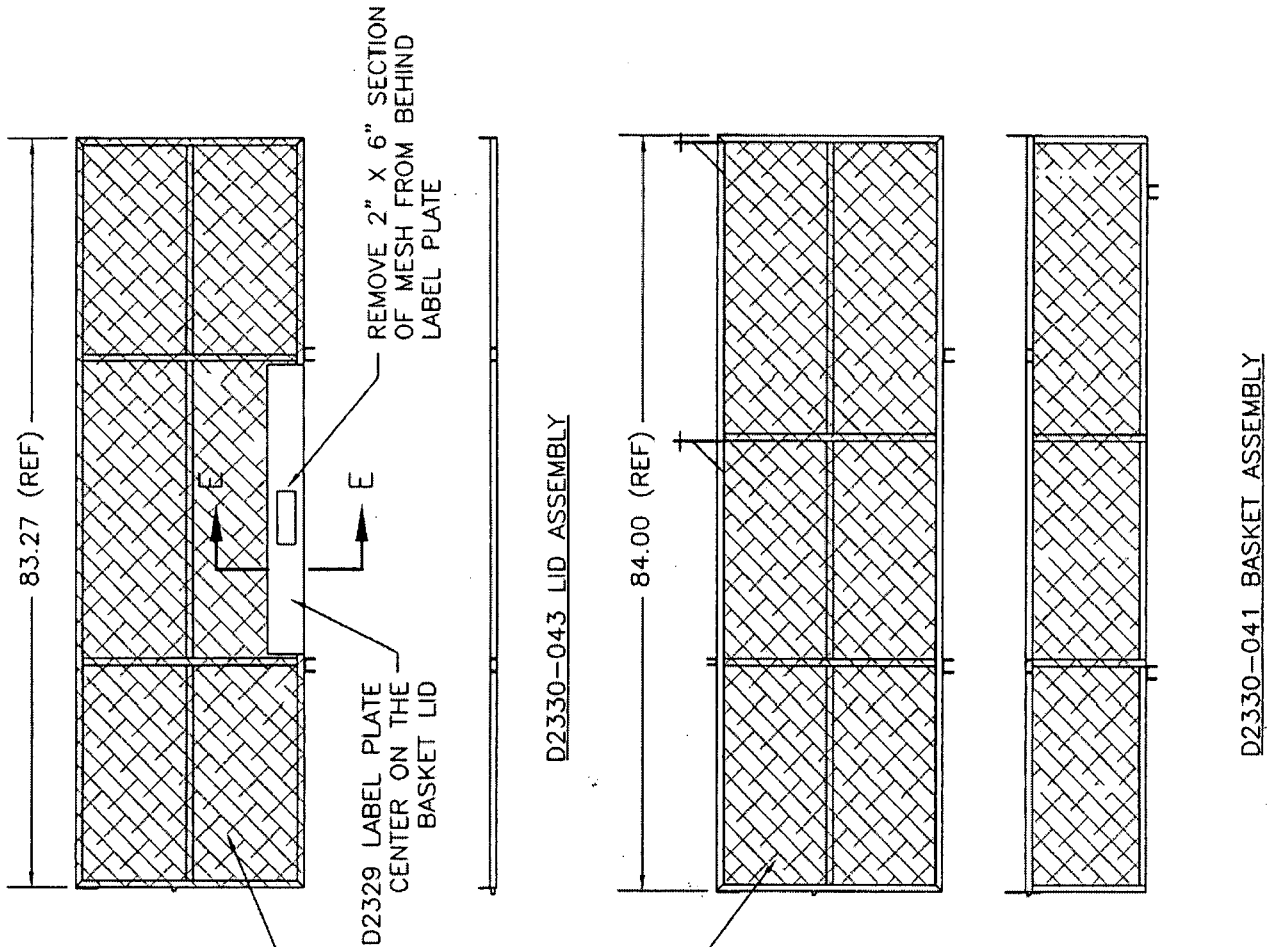


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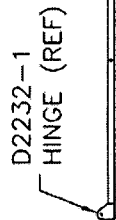
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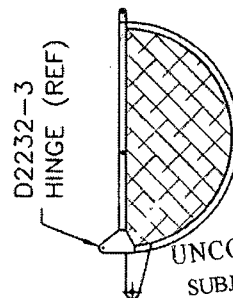


SECTION E-E



SKIN WITH 3/4-16 F  
EXPANDED SS, TACK  
WELD EACH STRAND  
END TO FRAME

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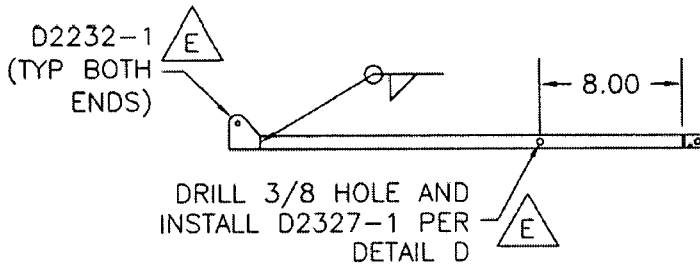
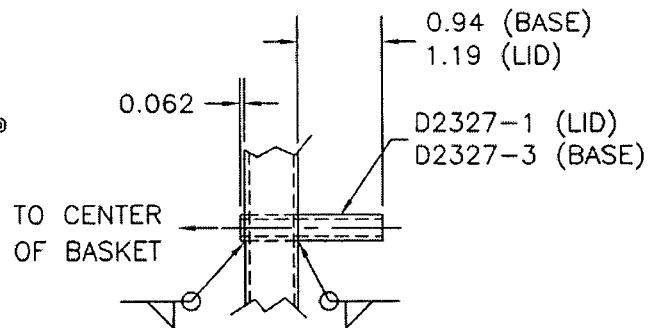
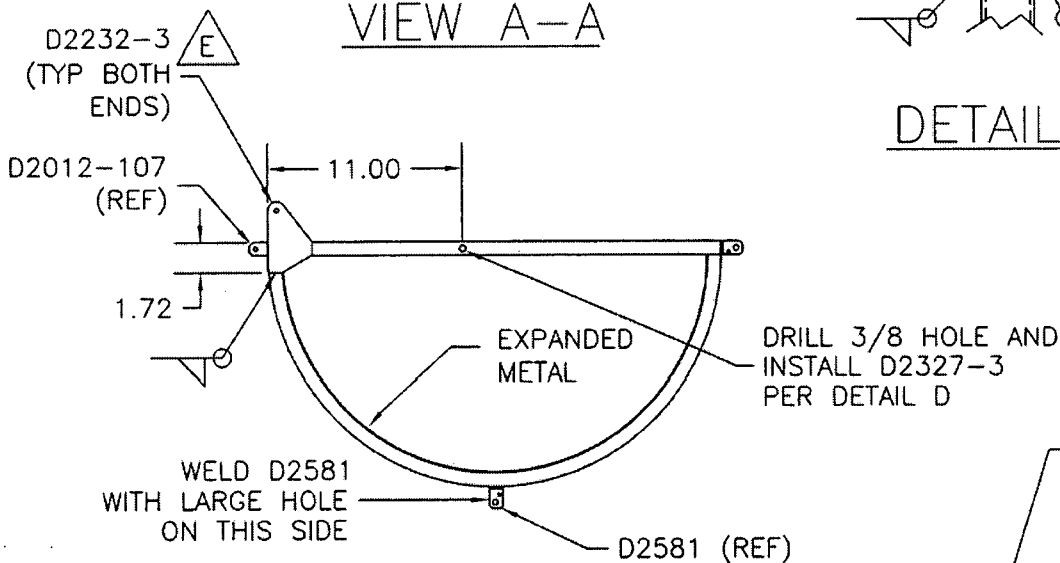
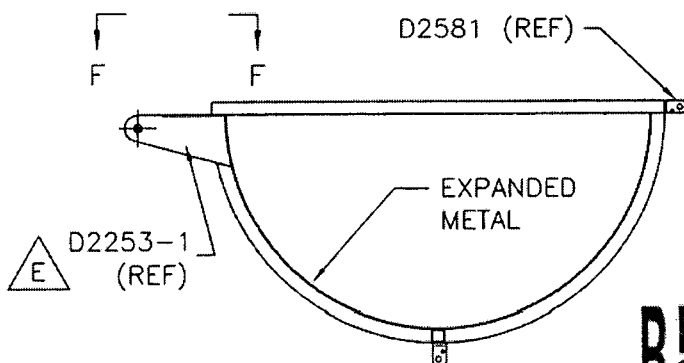
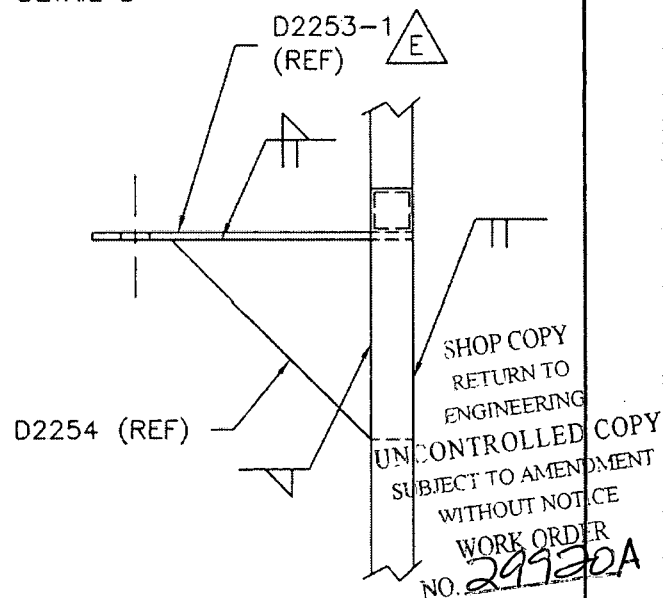
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VIEW A-ADETAIL DVIEW B-BVIEW C-CVIEW F-F**RELEASED**  
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